Work Order ID 110395 -2 SPLIT *110395*

December-18-13 8:50:25 AM

Item ID: D4635-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Fwd Ceiling Panel, RH **Stop** *NS2*

Start Date: 12/18/13 **Start Qty:** 2.00 *2* 1

Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLS **Date:** 13-12-18 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4635	~~PDT~~ Rev E DAS 27 9-89 per ECN 14-509								
100		0.00							
100	HAND FINISHING THERMOFORMING					x2			13/17/19
Thermoform	**Memo**	0.00							
Thermoforming Machine	Cut Blanks								
105		0.00							
105	Dry Material					x2			13/17/19
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								

Temp: 345°F

Time IN: 700 am 13/17/18

Time OUT: 700 am 13/17/19

Item ID: D4635-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, RH

Start Date: 12/18/13 **Start Qty:** 2.00 *2*
Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					x2			LL 13/12/19
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4635-2 and Folio FTA148								
	Dwg. Rev. P01								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00				1			BB 14/04/1(
130	HAND FINISHING THERMOFORMING					x1			BB 13/12/22
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						x1			LL 13/12/22
QC	**Memo**	0.00							
Quality Control									

Item ID: D4635-2
Revision ID:
Item Name: Fwd Ceiling Panel, RH
Start Date: 12/18/13 **Start Qty:** 2.00 *2*
Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*
Reference:

Accept *N900040100* Setup Start *NS1* Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1* Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00				1			
150 QC Quality Control	Memo	0.00							
160		0.00							
160 Packaging Packaging	Packaging		USE on w/o B111201			①		SAD 13/01/12	
	Memo	0.00							
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	Memo	0.00							

89-6 27 DAS 11/15/23

Inspect per Rev F

MCO 14-01-23

12/13/23

MF 14-1-17

POSITIVE RECALL
EFFECTIVE 12.15 AUTH
RELEASED DATE

DAS 27 9-89

Release Dwg Rev E 14/1/23

Picklist Print

December-18-13 8:50:29 AM

Work Order ID: 110395 *110395*

Parent Item: D4635-2 *D4635-2*

Parent Item Name: Fwd Ceiling Panel, RH

Start Date: 12/18/13 **Required Date:** 12/31/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL IPP Rev D Dwg. Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,838.000	14.9	30			
MLEXS.093-F6006-07									**	30	JB	13/12/23	
GE PLASTICS LEXAN SHEET													

Location	Loc Qty	Loc Code	
MAT023	2067.26		
114459	229.26		
123105	38		
124501	1800		

DART AEROSPACE LTD	Work Order:	110395
Description:	Part Number:	~~H0395~~ D4635-2.
Inspection Dwg: ~~PDI~~ Rev: PDI		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than ✓ "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL	Date:	14/01/15

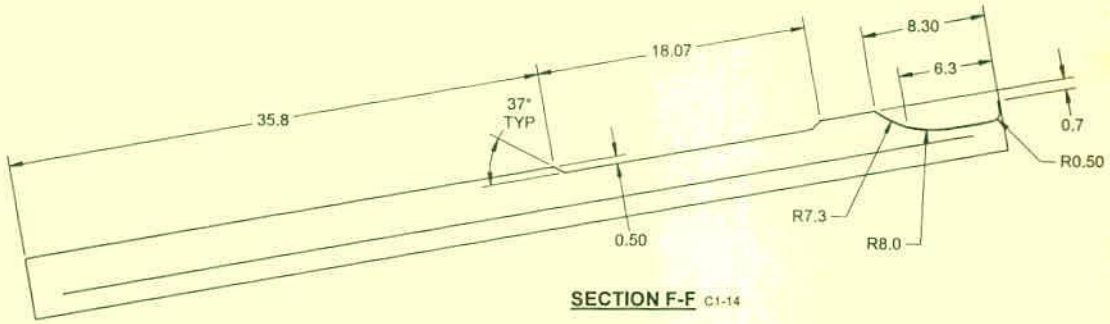
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
65.75"		65.75"	✓			
15.45"		15.45"	✓			
Ø 3.50"		3.53"	✓			
Ø 2.03"		2.00"	✓			
Ø 0.196"		0.195"	✓			
Ø						

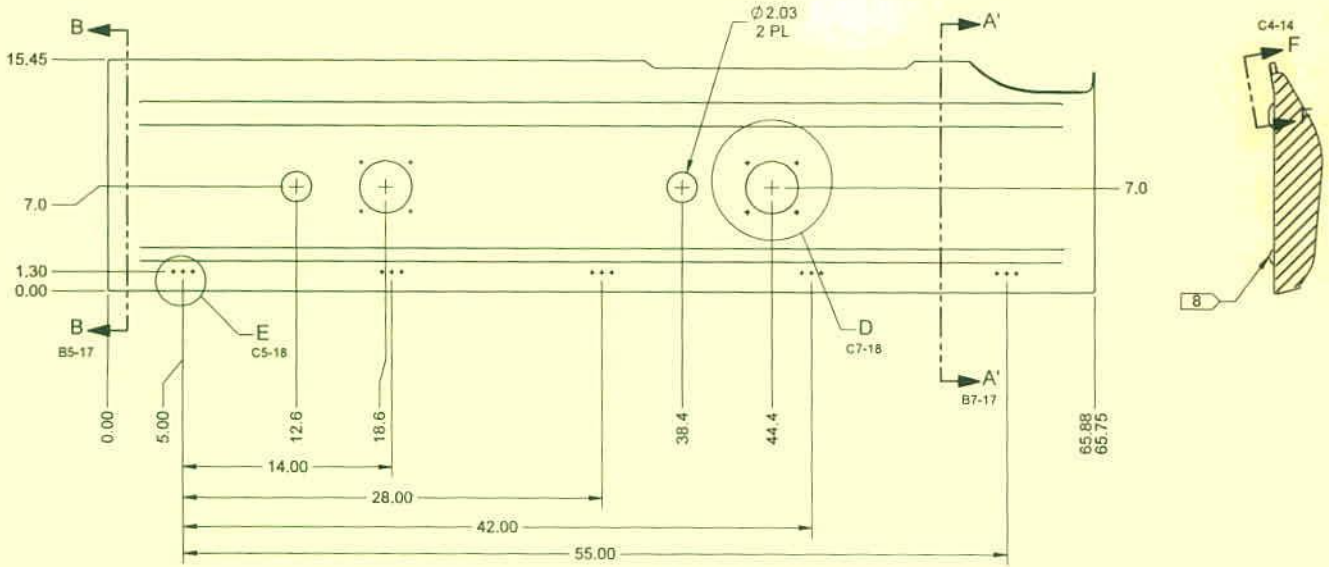
Measured by:	DAS 27 9-89 DL	Date:	14/01/15
Audited by:		Date:	14/1/23
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



SECTION F-F C1-14



NOTES:
1) MATERIAL: F6006 SUEDE POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.37 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-2 PER TOOL DT9840
10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-2 RH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 14 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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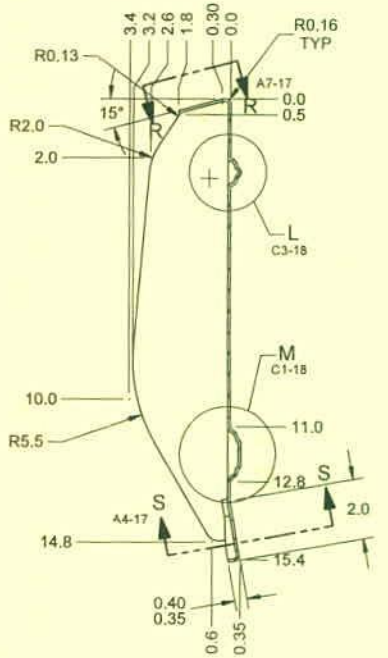
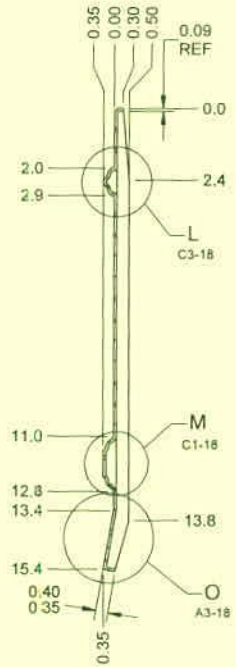


SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



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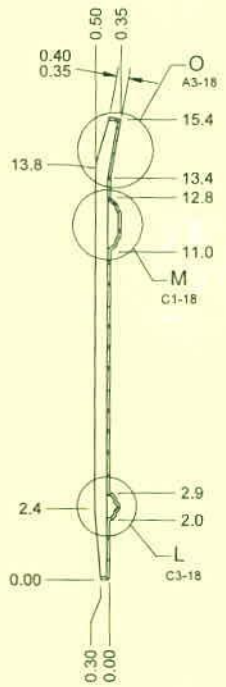
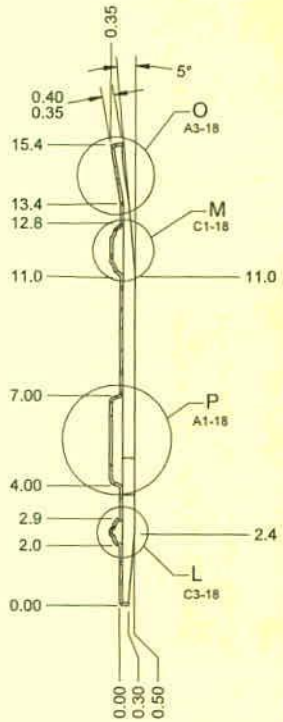
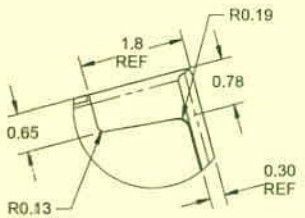


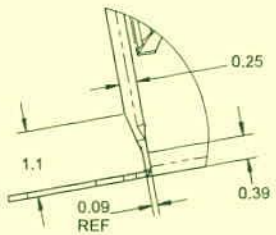
SECTION G-G B4-15 B4-16
SCALE 2X



SECTION K-K C6-16
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X



AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1 SHEET 17 OF 18
MFG. APPR.		
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
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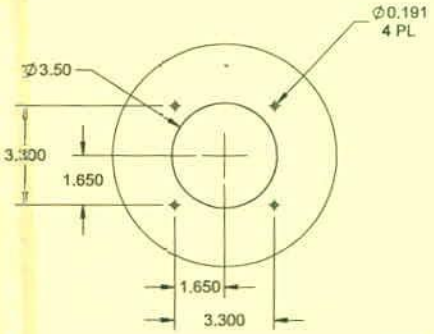

DETAIL D B4-13 B3-14 B5-15 B5-16
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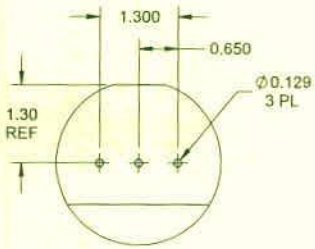

DETAIL E C7-13 B6-14 C6-15 B5-16
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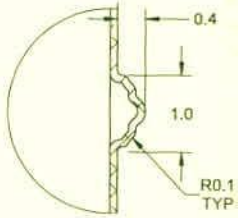

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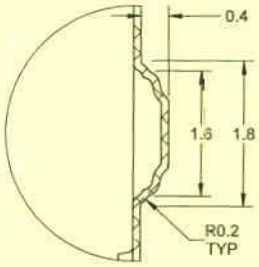

DETAIL M C2-17 C3-17 C5-17 C7-17
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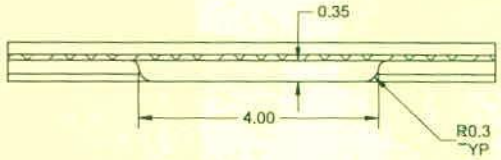

SECTION I-I B5-16
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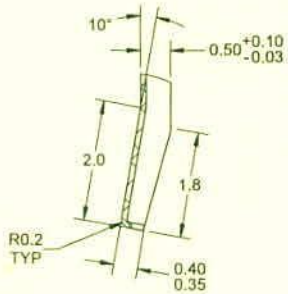

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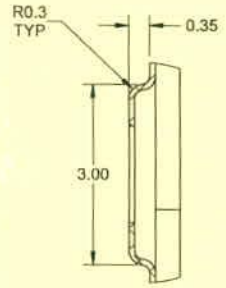
SCALE 2X



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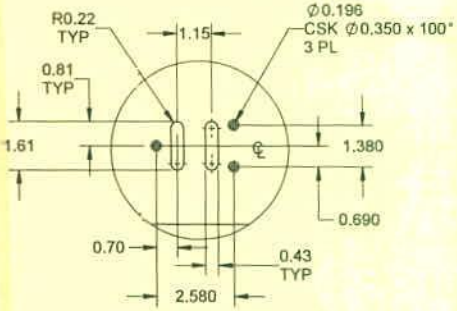
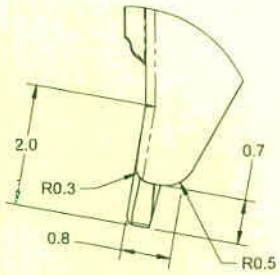


DETAIL O C5-16
SCALE 2X



DETAIL N B2-13
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 18 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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DART AEROSPACE LTD

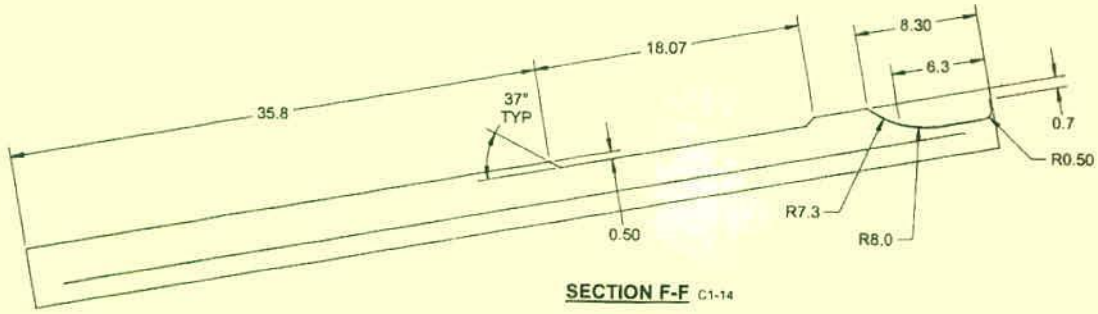
DART AEROSPACE

Description:	Fwd Cooling Panel RH	Work Order:	5
Inspection Drawing:	D4635	Rev: PE1	Part Number: D4635-2

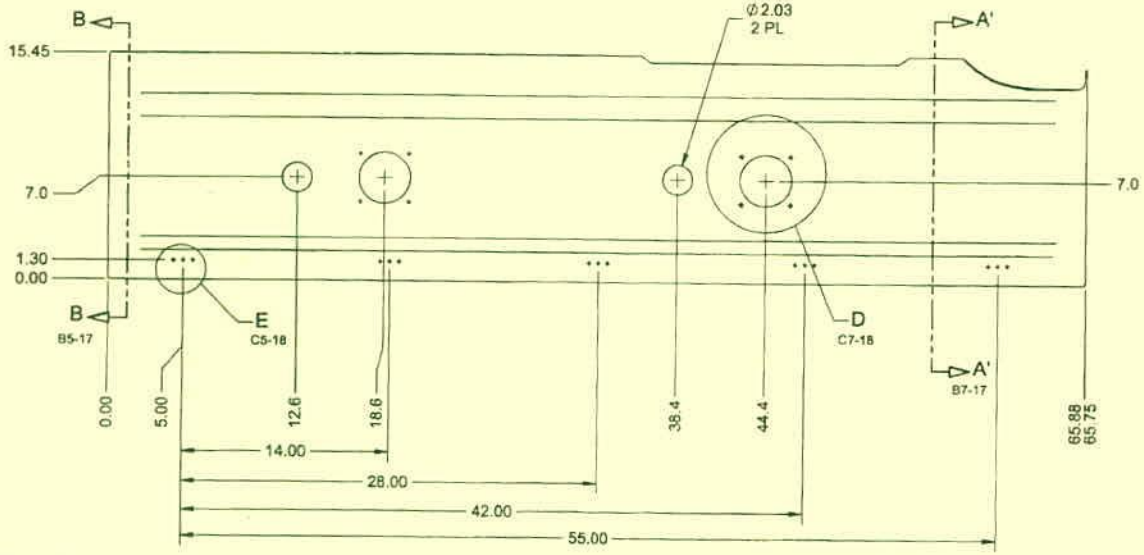
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.30	+/- 0.030	1.31				
7.60	"	7.60				
15.46	"	15.48				
14.60	"	14.60				
28.60	"	28.60				
55.60	"	55.60				
12.6	"	12.6				
18.6	"	18.6				
38.4	"	38.4				
44.4	"	44.4				
Ø.203	"	0.203				
~~Ø.20~~	"	0.				
Ø.350	"	0.3514				
Ø.191	"	0.194				
5.60	"	5.60				
1.300	"	1.2996				
0.650	"	0.654				
Ø.129	"	0.130				
3.300	"	3.3001				
1.650	"	1.654				

Measured by: DAS 27 9-89	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date 14/1/16	Date	Date	Date



SECTION F-F C1-14



NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.37 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-2 PER TOOL DT9840
10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-2 RH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4635 REV. E
MFG. APPR.		SHEET 14 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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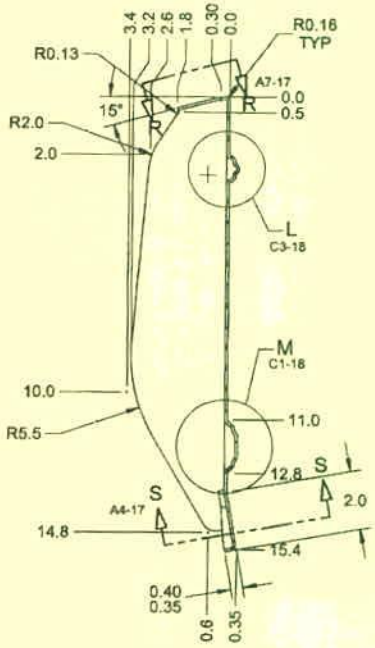
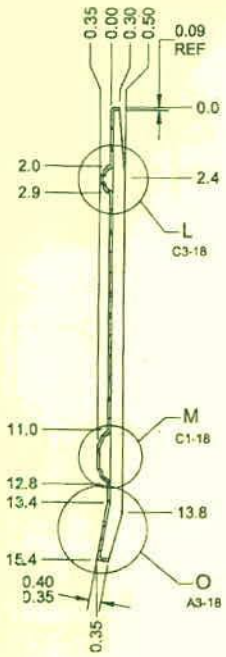


SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



SECTION B-B B7-13 B7-14
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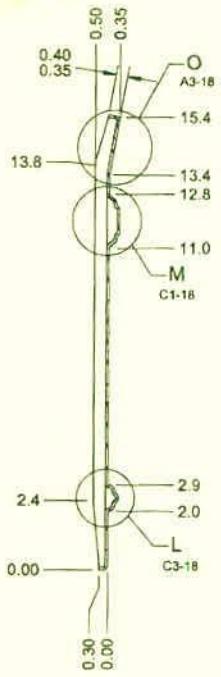

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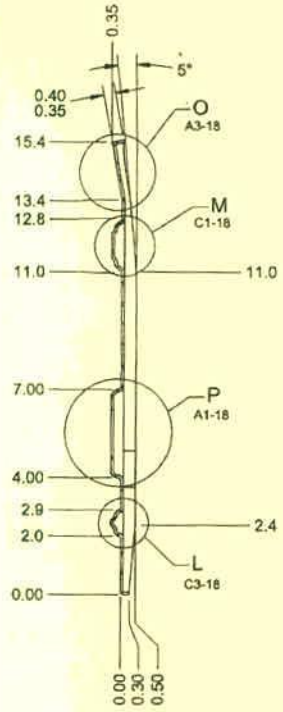

SECTION K-K C6-16
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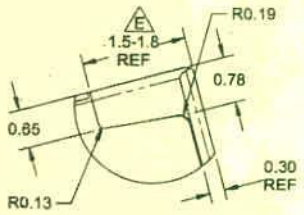
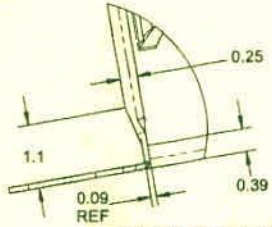


AUXILIARY VIEW R-R D7-17
SECTION R'-R' OPPOSITE
SCALE 2X



AUXILIARY VIEW S-S B7-17
SECTION S'-S' OPPOSITE
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.		D4635	SHEET 17 OF 18
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD CEILING PANELS	NTS
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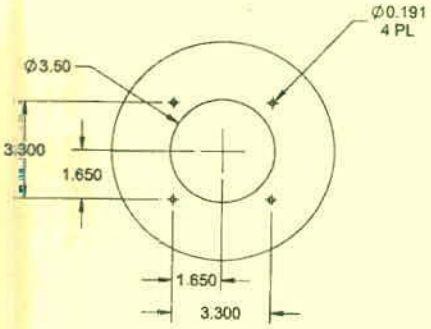
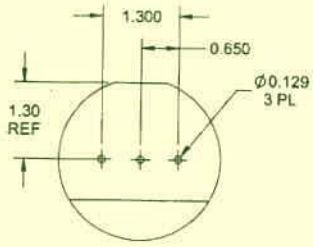
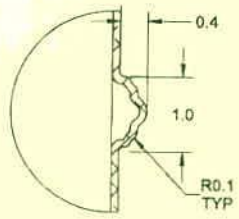


DETAIL D B4-13 B3-14 B5-15 B5-16
SCALE 2X



DETAIL E C7-13 B6-14 C6-15 B5-16
SCALE 4X



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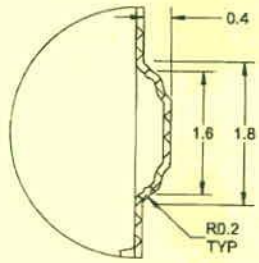

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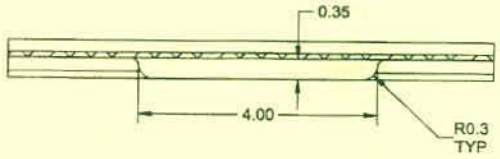

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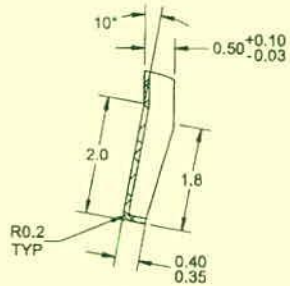

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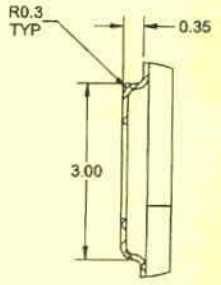

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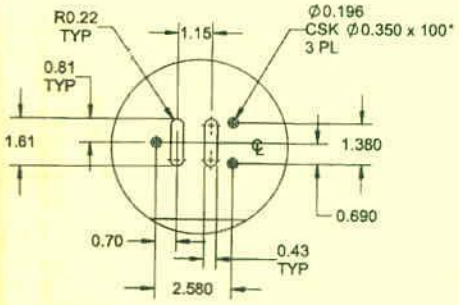

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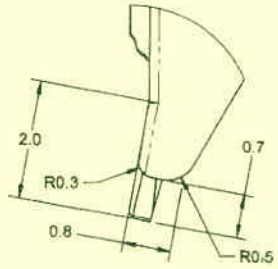

DETAIL N B2-13
SCALE 2X

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